

Thursday, December 22, 2016 10:52:47 AM

Page 1

Approvals: **Process Plan:** vmf **Date:** 16-12-22 **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

Work Order ID 154854***154854***

Page 2

Thursday, December 22, 2016 10:52:47 AM

Item ID: D5021-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Foam, Center Panel, Middle
Start Date: 12/22/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/13/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>ST479A</u>	0.00				<u>4</u>	<u>MAR 0 6 2017</u>		<u>DAS</u> <u>6</u> <u>9-89</u>
140									
Packaging	Memo	0.01							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00					<u>DAS</u> <u>21</u> <u>9-89</u>	<u>MAR 0 7 2017</u>	
150									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89MAR 0 7 2017

Picklist Print

Thursday, December 22, 2016 10:52:47 AM

Page 1 / 1

Work Order ID: 154854

154854

Parent Item: D5021-3

D5021-3

Parent Item Name: Foam, Center Panel, Middle

Start Date: 12/22/2016

Required Date: 1/13/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.04.09 NOW OUTSOURCE DD VERF:JLM

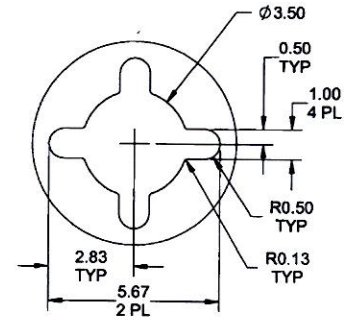
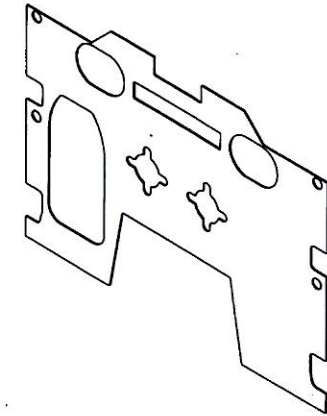
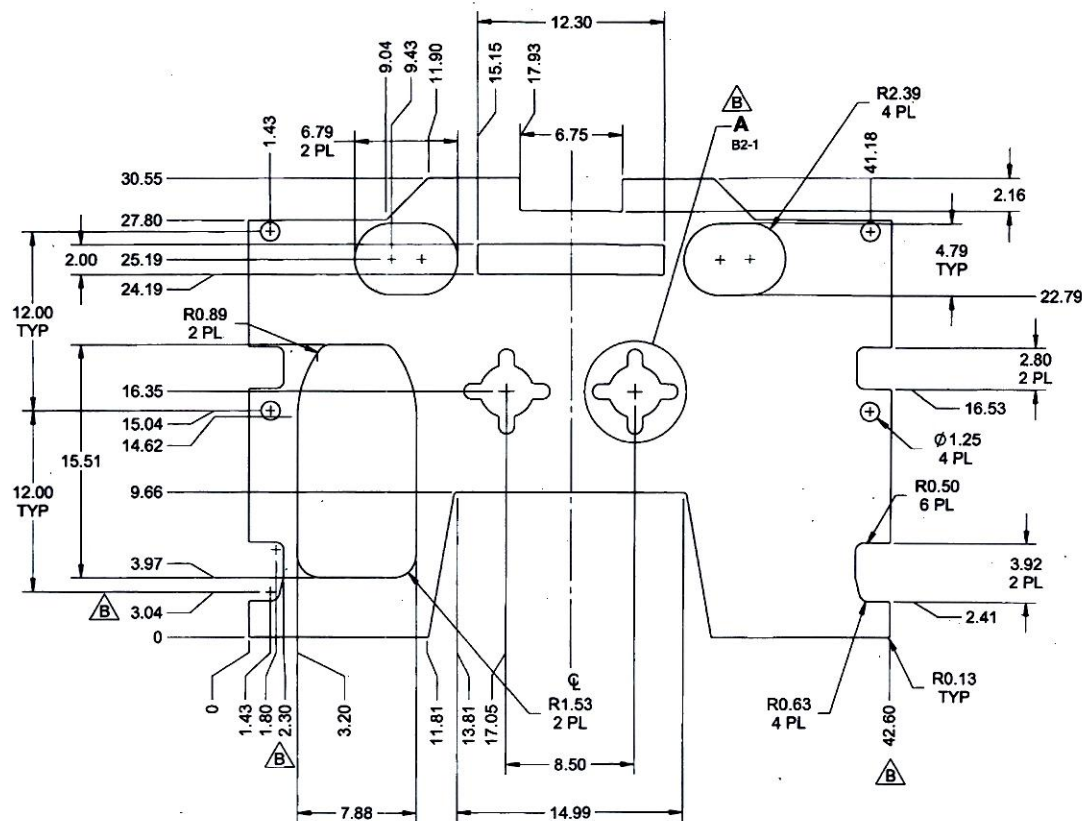
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5021-3P *D5021-3P* Foam, Center Panel, Middle		Purchased			No		Each	0.0000	**	4		12/17/16/27	

DS033-1

W

1605 each

38⁰⁰ total

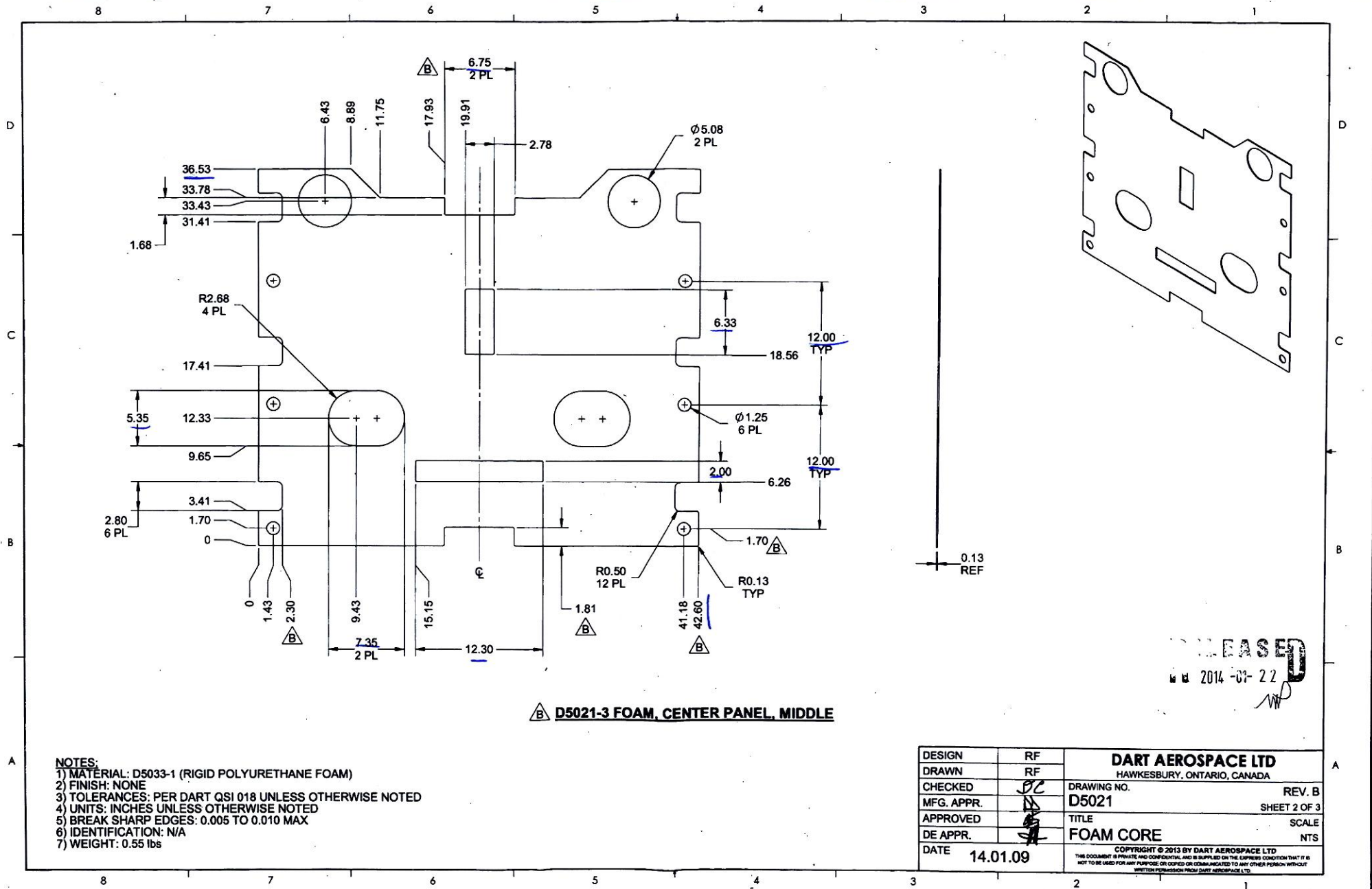


D5021-1 FOAM, CENTER PANEL, FWD

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

B	ADDED DETAIL A (ZN B2-1, D5-1) & 1.81 (ZN B5-2, B5-3); 6.75 (ZN D6-2, B6-3); 3.04 WAS 2.93 (ZN B7-1); 2.30 WAS 1.64 & 1.51 (ZN B7-1, B7-2, B7-3); 1.70 WAS 1.83 (ZN B4-2); 9.90 WAS 9.78 (ZN B4-3); SOME DIMENSIONS SHIFTED DUE TO WIDTH CHANGE	RF	14.01.09
A	NEW ISSUE	RF	13.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JL	DRAWING NO.	REV. B
MFG. APPR.	JL	D5021	SHEET 1 OF 3
APPROVED	JL	TITLE	SCALE
DE APPR.	JL	FOAM CORE	NTS
DATE	14.01.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IF NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

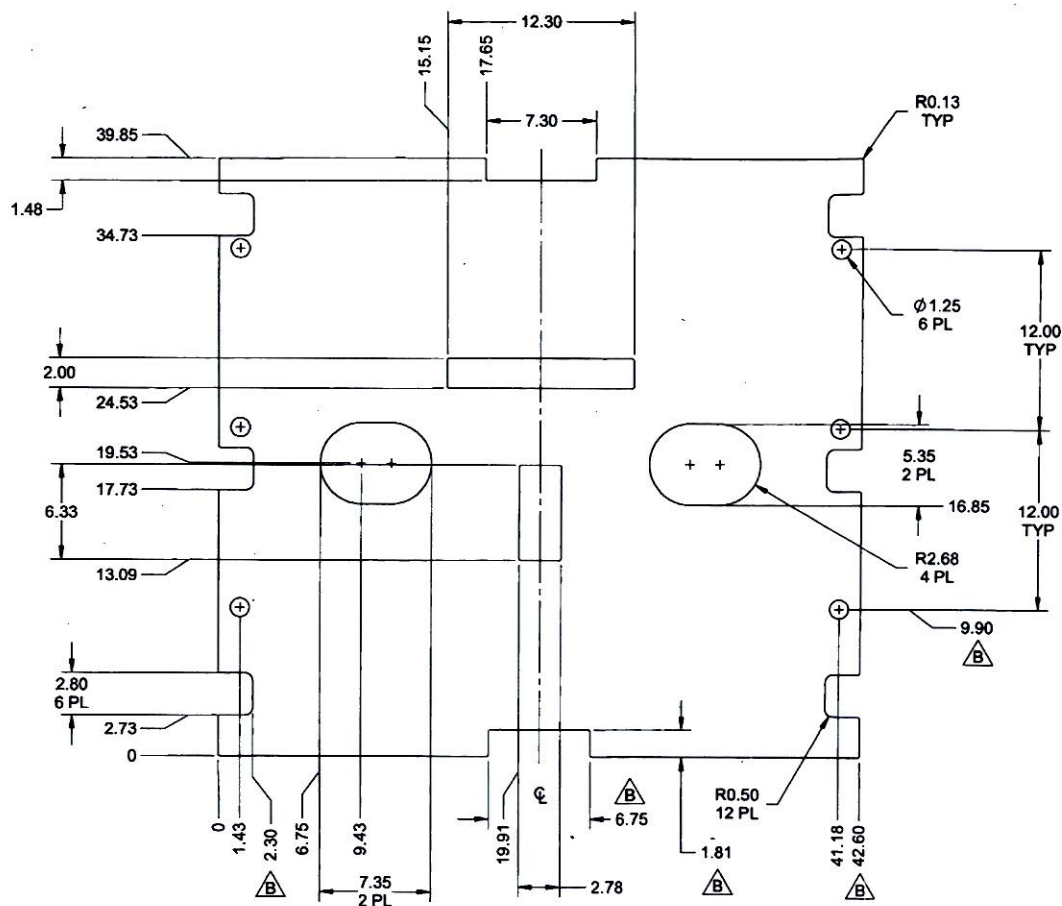


D5021-3 FOAM, CENTER PANEL, MIDDLE

- NOTES:**
- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 to 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.55 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PL</i>	DRAWING NO. D5021	REV. B
MFG. APPR.	<i>PL</i>	SHEET 2 OF 3	
APPROVED	<i>PL</i>	TITLE	SCALE
DE APPR.	<i>PL</i>	FOAM CORE	NTS
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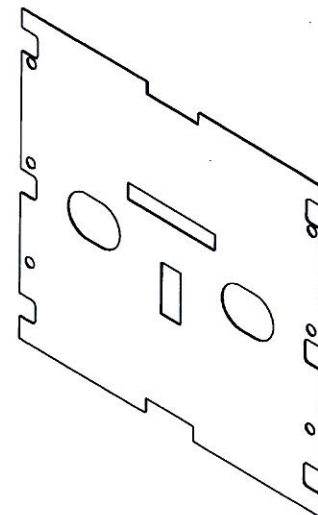
8 7 6 5 4 3 2 1



D5021-5 FOAM, CENTER PANEL, AFT

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs



RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	PC	D5021	SHEET 3 OF 3
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	FOAM CORE	NTS
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DART AEROSPACE LTD		Work Order: 154854
Description: Foam Center panel		Part Number: 5021-3
Inspection Dwg: 5021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ 1.25	-0.001 +0.012	φ 1.249	1		Tape	
φ 5.08	-0.001 +0.012	φ 5.08	1			
2.00	+/- .030	2.00	1			
5.35	+/- .030	5.35	1			
7.35	+/- .030	7.35	1			
12.30	+/- .030	12.30	1			
6.75	+/- .030	6.75	1			
12.00	+/- .030	12.00	1			
12.00	+/- .030	12.00	1			
42.60	+/- .030	42.60	1			
36.53	+/- .030	36.53	1			
6.33	+/- .030	6.33	1			
2.80	+/- .030	2.80	1			
1.70	+/- .030	1.70	1			
1.43	+/- .030	1.43	1			

Measured by: <i>ac</i>	Audited by: <i>DAS 38 9-89</i>	Preliminary Approval:
Date: 17/02/27	Date: MAR 06 2017	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	